

Work Order ID 60894

Monday, July 26, 2010 1:55:49 PM



Page 1

Item ID: D4148-041

Accept



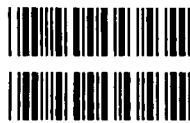
Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-7-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4148 | B |

100



Small Fab

0.00

Memo

0.00

Small Fab

1- Assemble as per dwg

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

120

Identify as per dwg & Stock Location: 468

0.00

Packaging

Packaging

Memo

0.00

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60894

Monday, July 26, 2010 1:55:49 PM



Page 2

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

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Customer:

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Approvals:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/2010

C2108124

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 1:55:52 PM

Page 1

Work Order ID: 60894



Parent Item: D4148-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/26/2010

Required Date: 8/2/2010

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC□
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Start Qty: 4.00

Required Qty: 4.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 1:55:52 PM

Page 2

Work Order ID: 60894



Parent Item: D4148-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

D3910-1



Manufactured

No

100

Each

24.0000

1

4

E/S 0/08/23

Crosstube Lug

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| st507 | 24 | |
| 59349 | 23 | |
| 59708 | 1 | |

D4091-1



Manufactured

No

100

Each

2.0000

1

4

E/S 0/08/23
B60874 (4x)

Mounting Lug

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST460 | 2 | |
| 60239 | 2 | |

AN3C12A



Purchased

No

100

Each

44.0000

4

16

E/S 0/08/23
M115392 (16x)

Bolts

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST351 | 44 | |
| 112314 | 8 | |
| 114761 | 22 | |
| 115016 | 14 | |

AN4C13A



Purchased

No

100

Each

104.0000

1

4

E/S 0/08/23

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST357 | 104 | |
| 113359 | 3 | |
| 114108 | 1 | |
| 114442 | 50 | |
| 114615 | 50 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Page 3

Monday, July 26, 2010 1:55:53 PM

Work Order ID: 60894



Parent Item: D4148-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

MS17984-C413

Purchased

No

100

Each

27.0000

1

4

PIN, QUICK RELEASE



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST297 | 4 | |
| 114340 | 4 | |
| ST314 | 23 | |
| 114523 | 1 | |
| 114774 | 2 | |
| 114886 | 20 | |

MS21043-3

Purchased

No

100

Each

2,985.000

4

Nut



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 76 | |
| 103691 | 76 | |
| ST301 | 2909 | |
| 107280 | 4 | |
| 112314 | 2905 | |

MS21043-4

Purchased

No

100

Each

1,220.000

1

Nut



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 40 | |
| 104603 | 40 | |
| ST301 | 1180 | |
| 112492 | 25 | |
| 113069 | 8 | |
| 114348 | 347 | |
| 114523 | 500 | |
| 114784 | 300 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

Work Order ID: 60894



Parent Item: D4148-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0332R

Purchased

No

100

Each

3,480.000

8

32

Washer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST297 | 3480 | |
| 113524 | 10 | |
| 113737 | 150 | |
| 115000 | 3320 | |

NAS1149C0432R

Purchased

No

100

Each

724.0000

2

32

8

Washer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST297 | 724 | |
| 114292 | 134 | |
| 114742 | 590 | |

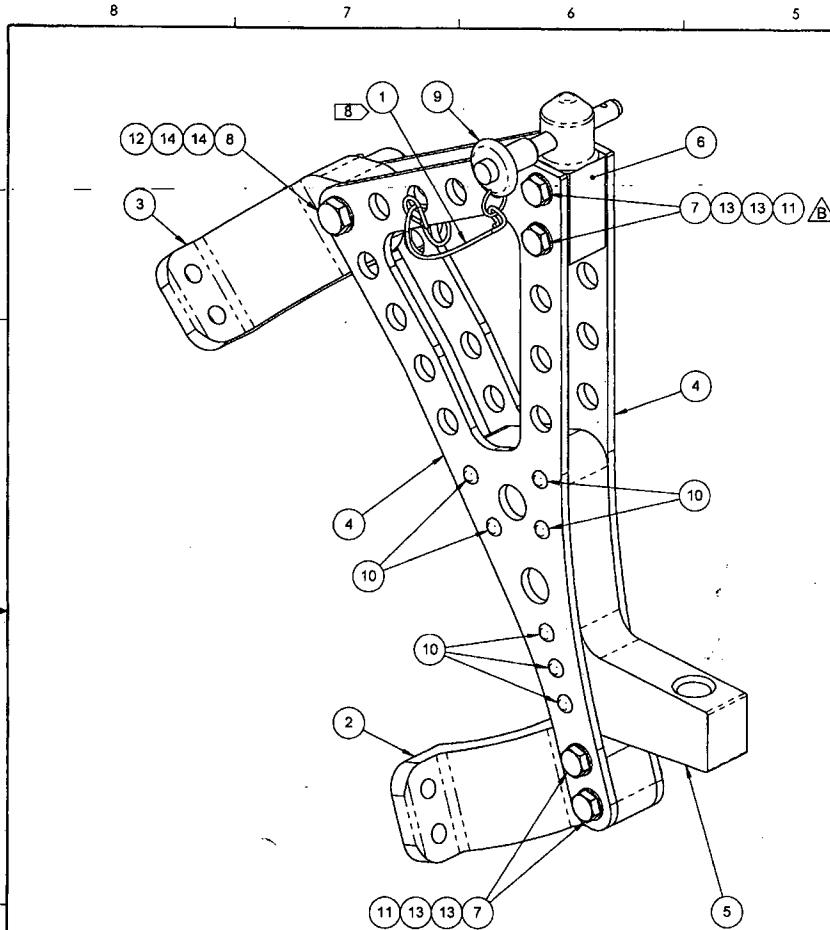
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NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.47 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60899*
28/07/26

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|----------------------|
| X | 1 | D4148-041 | FWD X-TUBE LUG ASSY |
| 1 | 1 | D2690-6 | LANYARD |
| 2 | 1 | D3910-1 | X-TUBE LUG |
| 3 | 1 | D4091-1 | MOUNTING LUG |
| 4 | 2 | D4148-1 | FWD X-TUBE LUG PLATE |
| 5 | 1 | D4148-3 | STUD RECEIVER LOWER |
| 6 | 1 | D4148-5 | EYEBOLT STUD |
| 7 | 4 | AN3C12A | |
| 8 | 1 | AN4C13A | BOLT |
| 9 | 1 | MS17984-C413 | PIP PIN |
| 10 | 7 | MS20615-4M18 | RIVET |
| 11 | 4 | MS21043-3 | NUT |
| 12 | 1 | MS21043-4 | NUT |
| 13 | 8 | NAS1149C0332R | WASHER |
| 14 | 2 | NAS1149C0432R | WASHER |

RELEASED
2010-07-16
28/07/26

| | | | |
|------------|---|--|--------------|
| B | REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS QTY(3) PL (ZN A7-3, B7-2 & B4-2); MS20615-4M18 PL WAS 10 PL (ZN A7-3, B7-2 & B4-2); QTY(2) WAS 0.129 (ZN C8-5). REASON: SEE TR-D350-607-2 REV. B. | MB | 10.07.05 |
| A | NEW ISSUE | MB | 10.06.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>10</i> | DART AEROSPACE LTD | |
| DRAWN | <i>10</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>10</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>10</i> | D4148 | SHEET 1 OF 5 |
| APPROVED | <i>10</i> | TITLE | SCALE |
| DE APPR. | <i>10</i> | FWD X-TUBE LUG ASSY | NTS |
| DATE | 10.07.05 | COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR SHOWN TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

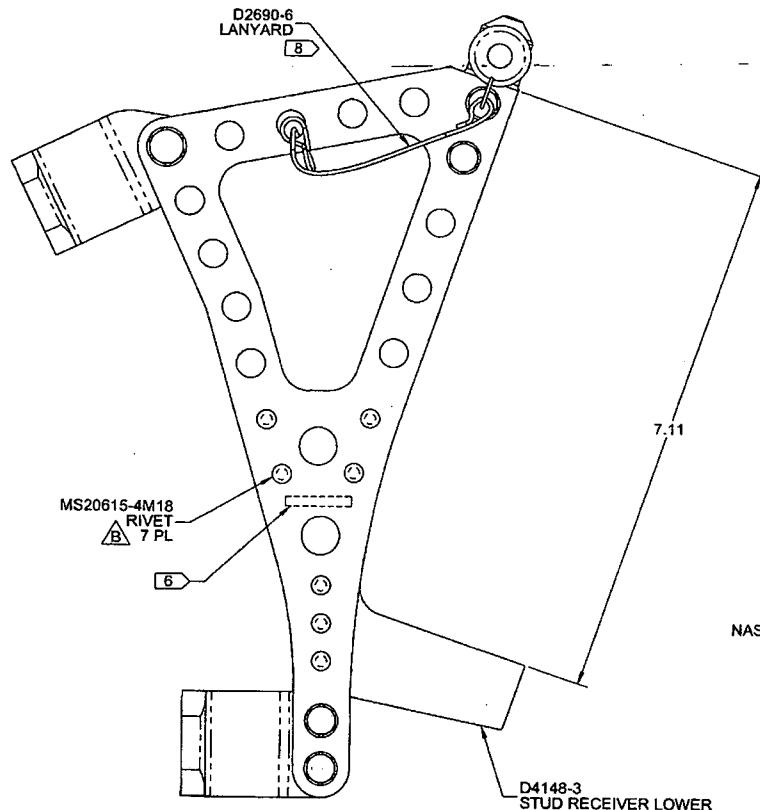
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

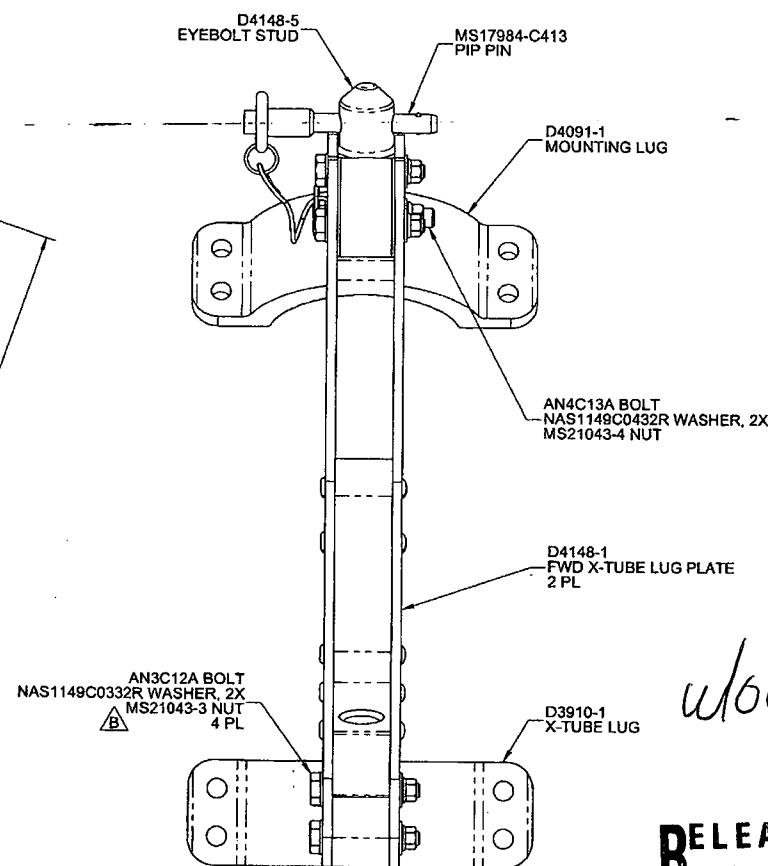
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY



RELEASED
2010-07-16
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|------------|--------------------|-----------------------------|--------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4148 SHEET 2 OF 5 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FWD X-TUBE LUG ASSY NTS | |
| DATE | 10.07.05 | | |

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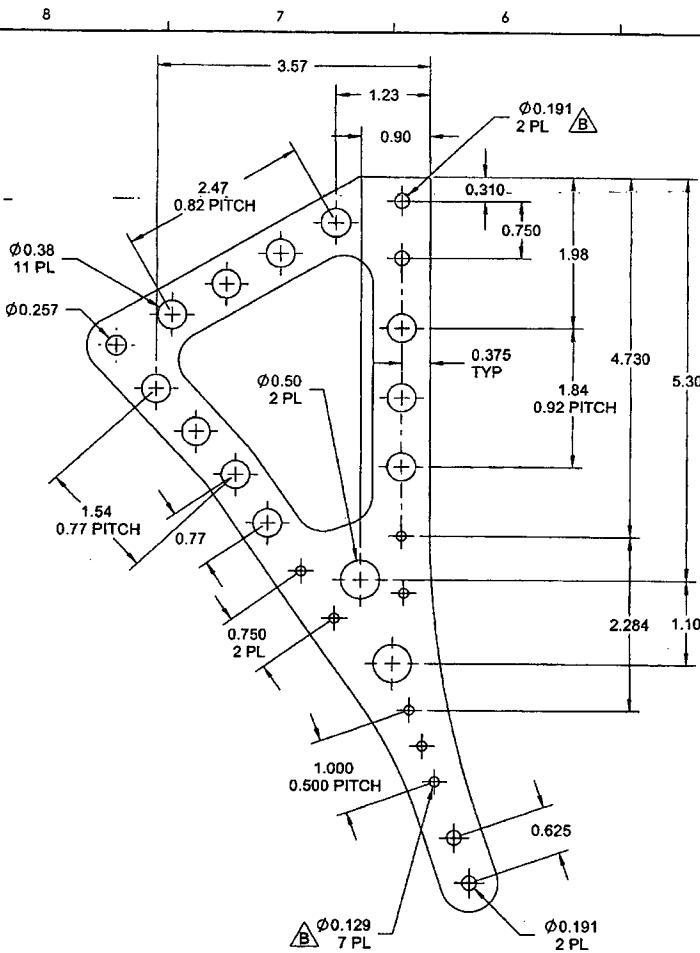
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

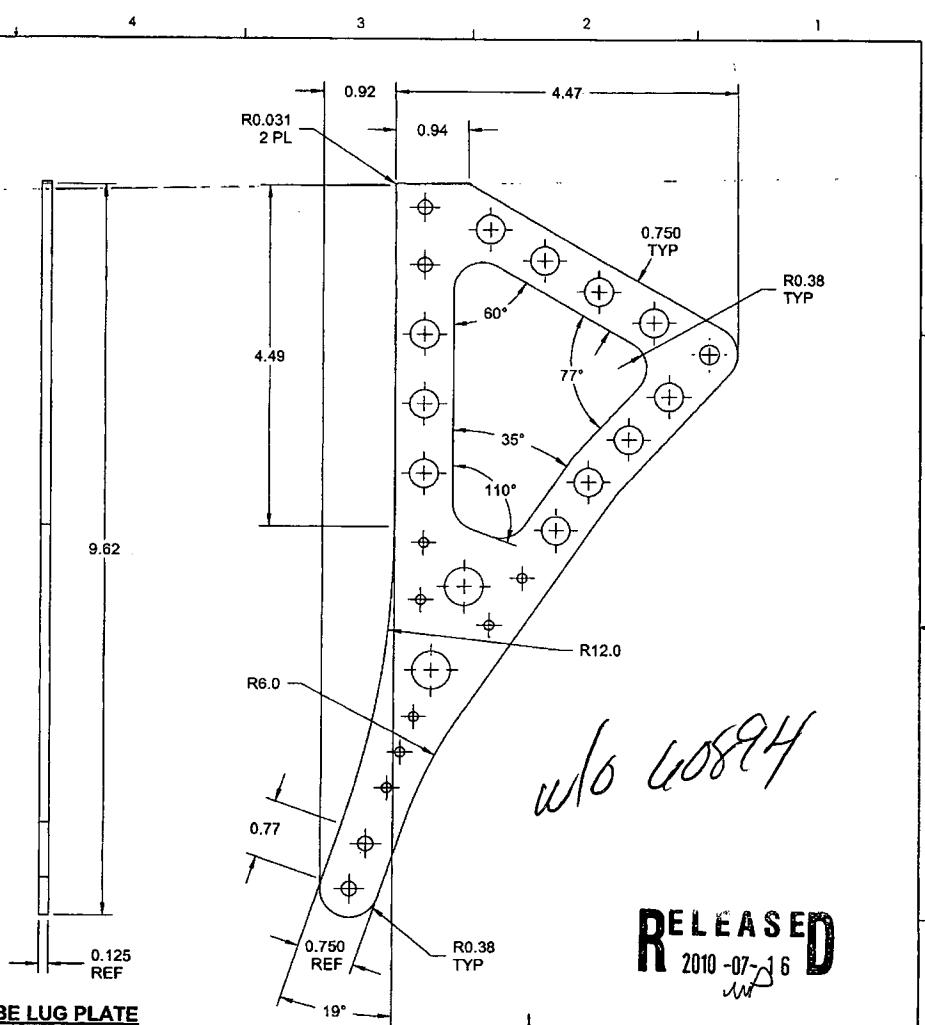
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NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC MS304S11GA OR MS303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.48 lbs

| | | |
|------------|--------------------|----------------------------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4148 |
| MFG. APPR. | <i>[Signature]</i> | REV. B |
| APPROVED | <i>[Signature]</i> | SHEET 3 OF 5 |
| DE APPR. | <i>[Signature]</i> | TITLE FWD X-TUBE LUG ASSY |
| DATE | 10.07.05 | SCALE NTS |

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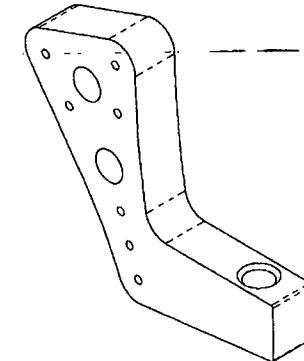
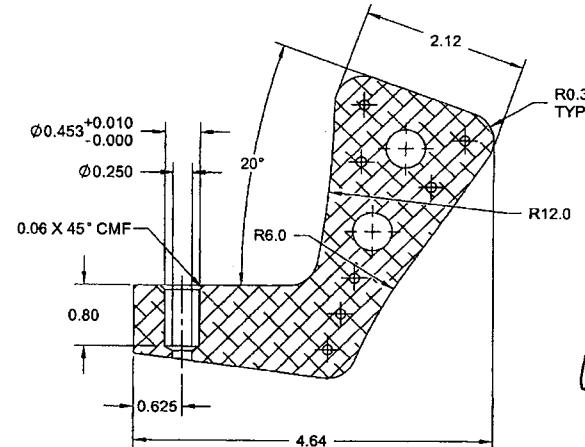
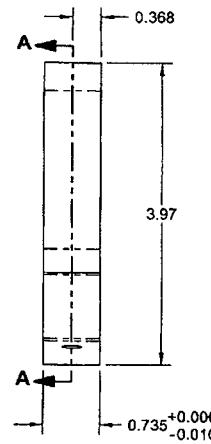
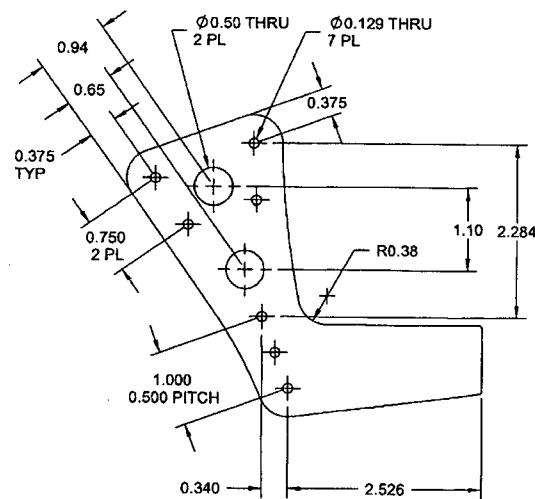
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



W/0 GO894

SECTION A-A

D4148-3 STUD RECEIVER LOWER

A NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.44 lbs

8 7 6 5 4 3 2 1

| | | |
|------------|--------------------|----------------------------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4148 |
| MFG. APPR. | <i>[Signature]</i> | REV. B |
| APPROVED | <i>[Signature]</i> | SHEET 4 OF 5 |
| DE APPR. | <i>[Signature]</i> | TITLE FWD X-TUBE LUG ASSY |
| DATE | 10.07.05 | SCALE NTS |

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2010-07-16
[Signature]

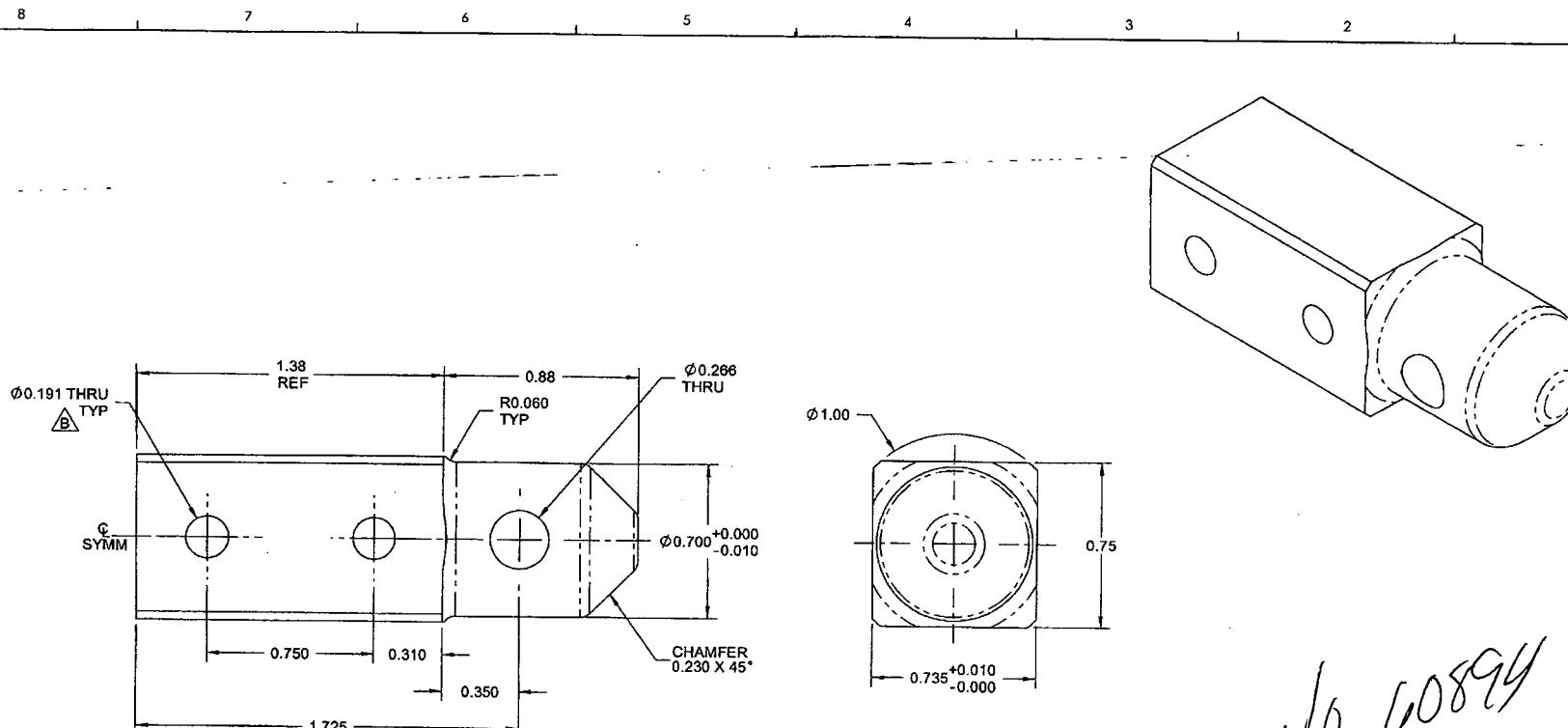
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

RELEASED
2010-07-16
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

| | | |
|------------|--------------------|-----------------------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4148 SHEET 5 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE |
| DE APPR. | <i>[Signature]</i> | SCALE |
| DATE | 10.07.05 | NTS |

FWD X-TUBE LUG ASSY

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NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT
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| W/O: | | WORK ORDER CHANGES | | | | | | | : | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | | | |
| | | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | : | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|---|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | | |
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NOTE: Date & initial all entries